

DOORS

Purpose

This document outlines the procedures to replace two side extrusions or side and top extrusions on the rear ramp door. If more than two extrusions need to be replaced or if the bottom or hinge side extrusion is to be replaced, contact LCI. Procedure is only applicable to ramp doors with corner keys and external fasteners.

Safety

⚠ CAUTION

The "CAUTION" symbol above is a sign that a procedure has a safety risk involved that may cause personal injury and/or product damage, including voiding of warranty, if not performed safely and in accordance with the safety procedures stated herein.

⚠ CAUTION

Moving parts can pinch, crush or cut. Keep clear and use caution.

Resources Required

- Replacement extrusions, maximum of two
- Cordless or electric drill or screw gun
- Appropriate drive bits
- 5/32" T-handle
- Rubber mallet
- Five-way tool
- Putty knife
- Screw extractor
- White gunnable glue
- Glue gun
- Caulk
- Caulk gun
- Clamps

Procedure

1. Use T-handle to loosen screws on the corner keys of the damaged extrusions to be replaced (Fig. 1).

Fig. 1



2. Remove the screws from each end of the extrusions being replaced.

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3. On the interior side of the door, slide a five-way tool under the extrusion channels and tap with a rubber mallet every 4" along the channel to loosen the extrusion from the core (Fig. 2).

Fig. 2

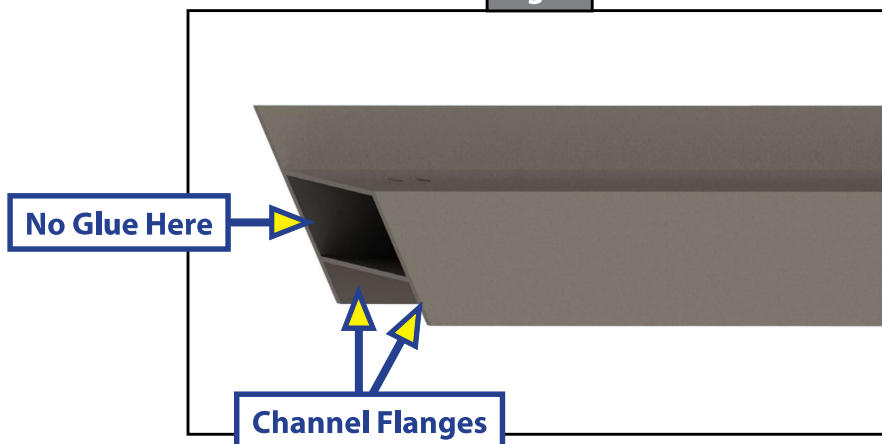


4. If the tool and tapping procedure doesn't break the extrusion free, turn the door over and repeat the procedure on the exterior side of the door.

NOTE: Take care not to scratch the fiberglass.

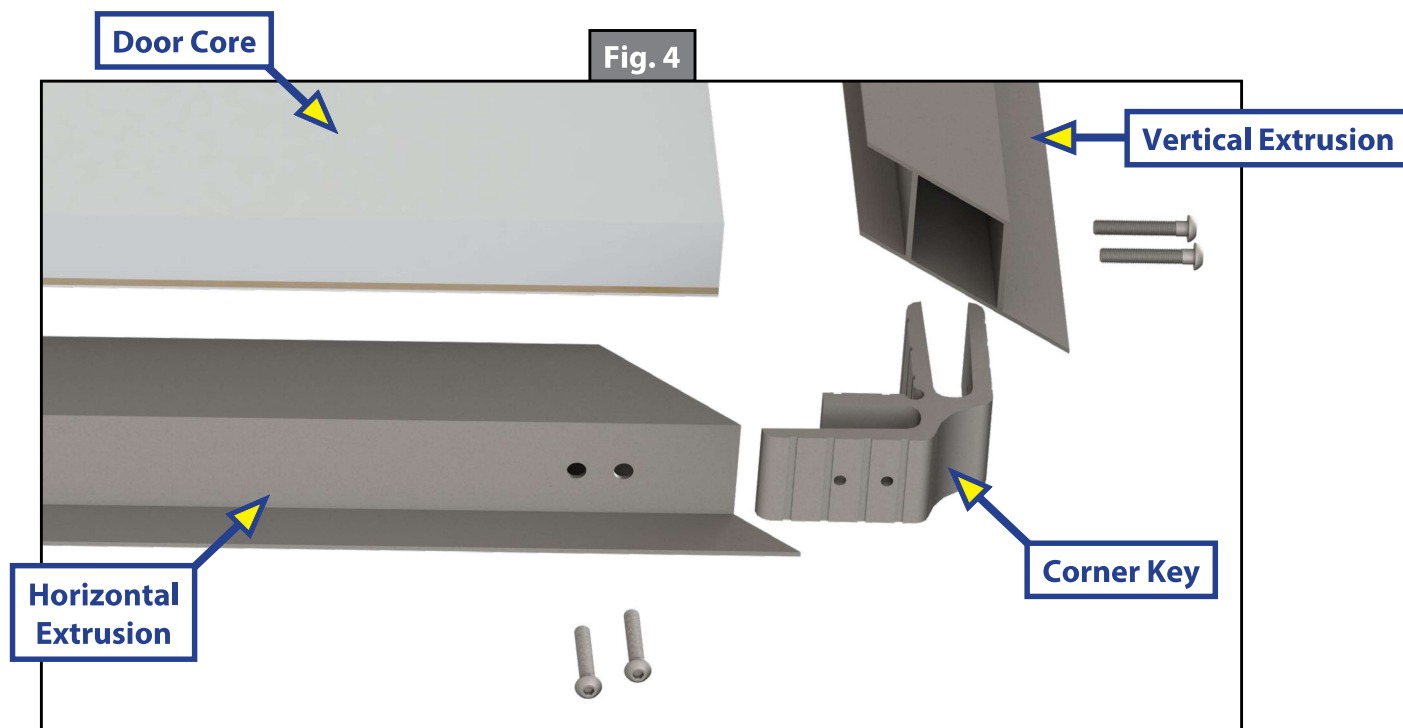
5. After removing the damaged extrusion, use the five-way tool to remove remaining glue from the interior side of the core.
6. Use a putty knife to remove remaining glue from the exterior side of the core.
7. Apply white glue end to end on both sides of the inside lip on the extrusion channels without leaving voids. The glue must be located only on the inside of the channel flanges (Fig. 3) and not in the corners.

Fig. 3

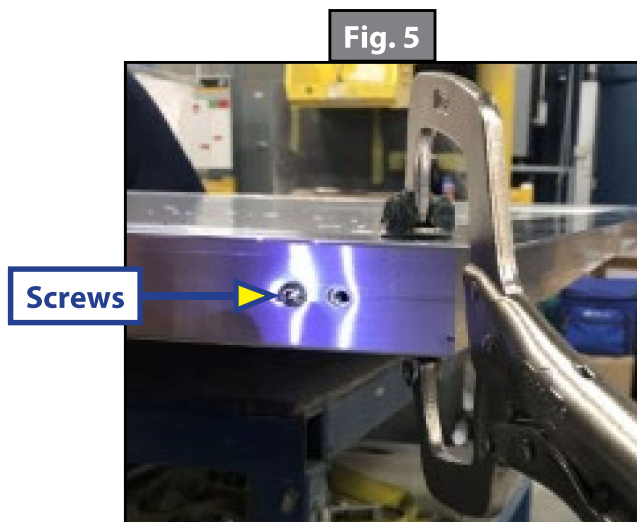


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8. Place corner keys into the ends of extrusions (Fig. 4) and then install the extrusion on the edge of the core. Seat extrusion with a rubber mallet. Corners must line up.



9. Make sure corner keys are fully seated into the ends of the corresponding extrusions.
10. Clamp the corners and install screws through the extrusions (Fig. 5). The screws must be installed flush with the extrusions.



11. Using a caulk gun, reapply caulk on the seams on both sides of the door.

As a supplier of components to the RV industry, safety, education and customer satisfaction are our primary concerns. Should you have any questions, please do not hesitate to contact us at (574) 537-8900 or by email at customerservice@lci1.com. Self-help tips, technical documents, product videos and a training class schedule are available at lci1.com or by downloading the MyLCI app.